

5/2/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C2-3-3

Job Sheet 176875



Part No: C2-3-3

Job Qty: 46 ea

Part Name: Latch Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/2/18

Job Tracking No:

Due Date: 5/4/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG C2-3-3 Rev 4A IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea		5/4/18	0.00	0.00	Start Up Machining-3		18-5-2
110	CNC Lathe	16 pcs		5/4/18	0.00	3.20	MORI SL-154		18-5-2
120	QC	16 pcs		5/4/18	0.00	0.00	QC2 Machining-4		18-5-2
130	QC	16 pcs		5/4/18	0.00	0.00	QC8 Machining-4		18-5-2
132	Outsource	16 pcs		5/4/18	0.00	0.00	Outsource1		18-05-08
134	Packaging	16 pcs		5/4/18	0.00	0.00	Packaging2		18-05-18
136	QC	16 pcs		5/4/18	0.00	0.00	QC6		18-05-18
138	CNC Lathe	16 pcs		5/4/18	0.00	5.33	MORI SL-154		18-5-19
140	QC	16 pcs		5/4/18	0.00	0.00	QC2 Machining-4		18-5-19
142	QC	16 pcs		5/4/18	0.00	0.00	QC8 Machining-4		18-05-30
148	Outsource	16 pcs		5/4/18	0.00	0.00	Outsource15		18-5-31
150	Packaging	16 pcs		5/4/18	0.00	0.00	Packaging2		18-05-31
160	QC	16 pcs		5/4/18	0.00	0.00	QC6		18-05-31
210	Packaging	16 pcs		5/4/18	0.00	0.00	Packaging3-1		18-05-31
220	QC21-SA	16 Ea		5/4/18	0.00	0.00	QC21		18-05-31

Part Op 110 - 1-Machine as per FOLIO FC041 FOLIO REV: _____ DWG REV: _____ 2- ***FINISH ID AFTER
 Descriptions: HEAT TREAT*** 3-Deburr
 132 - 1-Issue P/O to Metcore ; P/O 00039833 RC 53-56 2-Bead blast 3- Certificate of Conformity is required
 138 - 1-Machine as per folio FC041 FOLIO REV: _____ DWG REV: _____ 2-Deburr
 148 - 1-Issue P/O to Groupe Altech: P/O 040059 -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-
 .0006 -Bake after plating -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R0.750	4140 Round Bar .750	.5000 ft (.03125 ea)	90-Start up Operation	
	3048046	.70		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R0.750	1	5	0

Plex 5/2/18 2:00 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068693



Part: C2-3-3

Job No: 176875

Serial No/Batch: S068693

Revision: 4A

Inspector:

Date: 05/05/18

176875
C2-3-3
S068693

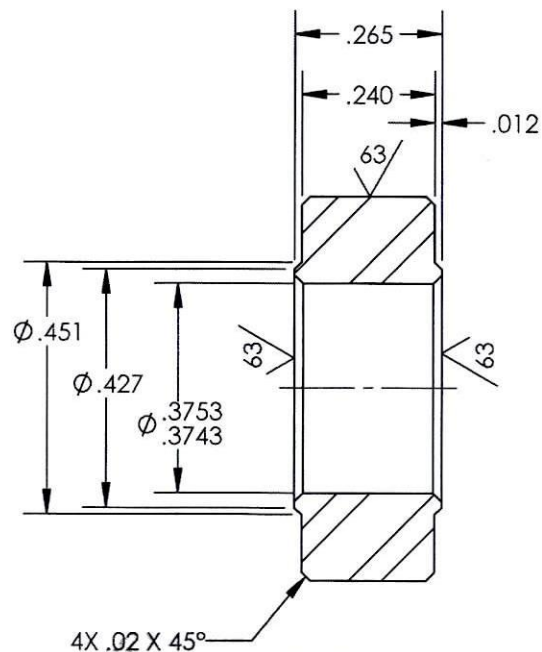
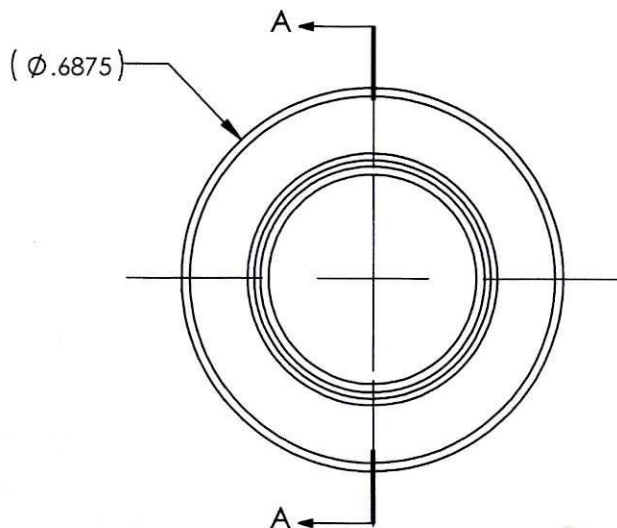
Part Specifications

Specifications could not be found.

Plex 5/2/18 2:00 PM Dart.Gagnon.Michelle

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM.	8/7/2012		
3		UPDATED BORE TOLERANCE FOR P.F. OF BEARING.	8/17/2012	RJC	SE
4		CH'D DIAMETER FROM Ø.457 TO Ø.451 TO ACHIEVE THE .012 DEPTH NEEDED.	10/25/2012	RJC	GE
4A	14-0105	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED NOTE 1. DELETED DUPLICATE DIMENSION 2X .015 X 45°. CH'D DIMENSION WAS 2X.015 X 45° IS 4X .02 X 45°. ADDED, NOTE 2 BAKE AFTER PLATING.	8/6/2014	DPD	RW



SECTION A-A

NOTE:

1. BAG & LABEL WITH BATCH NUMBER.
2. NICKEL PLATE .0004 - .0006 THICK, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE LATCH ROLLER	
DWG NO. C2-3-3	REV 4A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XX ± .005	HEAT TREAT HRC 53-56
XX ± .01	FINISH SEE NOTE 2
X ± .1	ANGLES ± 5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 3:1	DATE 11/7/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C2-3-3	1	LATCH ROLLER	4140	Ø11/16 X 3/8	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039833**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039833
PO Date: 5/8/18
Due Date: 5/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176875	C2-3-3	Latch Roller 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required -Material:4140	Firmed	5/18/18	20 pcs	0 pcs ✓ 60x	20 pcs	\$3.65/pcs 5/18/18	\$73.00
2	175633	C3-3-4	Link Pin 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** Material: Drill Rod	Firmed	5/18/18	30 pcs	0 pcs	30 pcs	\$2.43333/pcs	\$73.00
3	176725	C10-8	Trunnion Bushing 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech -Material:4140	Firmed	5/18/18	20 pcs	0 pcs	20 pcs	\$3.65/pcs	\$73.00

DAS
11
9-88

Certification

Date: 15/05/2018

Entry Date: 15/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039833

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
20	20 pcs material 4140 harden rc53-56 sand blast 176875 c2-3-3 cfc	1

DAS
11
9-89

MAY 18 2018

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWELL 53. 56. 55. tested as per sampling
heat treated to 55rc as per cust requested

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


 KEAN SHEPHERD
 QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040059**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040059
PO Date: 5/31/18
Due Date: 6/6/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173852	RBE350A93-3300-20	Tail Rotor Hub Socket -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs	12 pcs	\$3.79/pcs	\$45.48
2	177469	RBE350A93-3400-00-1	Guide -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs	12 pcs	\$3.20/pcs	\$38.40
3	173354	RBT400313-7	Bolt -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	7 pcs	0 pcs	7 pcs	\$1.75/pcs	\$12.25
4	176875	C2-3-3	Latch Roller -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	6/5/18	18 pcs 18	0 pcs 18x	19 pcs	\$10.4347/pcs At 18/06/06	\$198.26



Certificat de Conformité / Certificate of Compliance

(009916-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009916- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
04-Jun-2018		Jessie Boisvert		040059					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
4	C2-3-3 Rev.	C2-3-3 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL-200 CH	19	19	0	0	0	
5	C2-3-3 BAKE Rev.	C2-3-3 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	E-NICKEL-200 MIN-CHG	19	19	0	0	0	
7	C3-12-3 Rev.	C3-12-3 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK	E-NICKEL STEEL CH	4	4	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.